

Work Order ID 68711

Wednesday, April 20, 2011 9:13:03 AM



Page 1

Item ID: D3023-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Back Panel

Start Date: 4/20/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/21/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3023	Rev A								
100	FLOW WATER JET	0.00							
	Waterjet								
FLOW CNC Waterjet	Memo	0.00							
	1-Cut as per Dwg D3023								
	Dwg Rev: <u>1</u>								
	Prog Rev: <u>1</u>								
	***graind direction along 28.100" ***								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00							

B 11-4-26

①

B 11-4-20

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Page 2

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130

NC BRAKE

0.00



Brake NC

Memo

0.00

Brake NC

1-Bend as per Dwg D3023 2-form edge of back pan as per dwg D3023 using  
D3017-041 back frame

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

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Page 3

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Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				1		BR 11-4-27	
160  Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 MILS 128 Memo START TIME: 12:00 FINISH TIME: 12:30	0.00  0.00				1		BR 11-4-27	
170  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				1		11-4-27	

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Wednesday, April 20, 2011 9:13:03 AM



Page 4

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Cust Item ID:

Required Date: 4/21/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

Identify as per dwg & Stock Location: GA

0.00



Packaging

Memo

WOB 68624

0.00

Packaging

SA 11/04/27

(1)

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/27

11-04-27

# Picklist Print

Wednesday, April 20, 2011 9:13:00 AM

Page 1

Work Order ID: 68711



Parent Item: D3023-1



Parent Item Name: Back Panel

Start Date: 4/20/2011

Required Date: 4/21/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP C 02.01.23 Revised NG  
IPP Rev:D 08-04-16 now water jet DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.032

Purchased

No

100

sf

55.5000

2.8777

3.029158



FB11-4-20

2024-T3 .032 sheet

Location

Loc Qty

Loc Code

MAT22

55.5

111699

0.5

113189

55

113189

①

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 68711
<b>Description:</b> Back Panel		<b>Part Number:</b> D3023-1
<b>Inspection Dwg:</b> D3023	<b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	.129	X		U (Bo)	
Ø0.191	+0.005/-0.001	.194	X		U	
1.660	+/-0.010	1.657	2		U	
0.375	+/-0.010	.374	X		U	
1.340	+/-0.010	1.336	X		U	
2.375	+/-0.010	2.374	X		U	
0.375	+/-0.010	.375	X		U	
25.28	+/-0.030	25.28	X		T (Bo)	
27.03	+/-0.030	27.03	X		T	
28.10	+/-0.030	28.10	X		T	
1.30	+/-0.030	1.294	X		U	
2.375	+/-0.010	2.378	X		U	
8.711	+/-0.010	8.711	U		T	
5.597	+/-0.010	5.597	U		T	
8.57	+/-0.030	8.57	U		T	
1.970	+/-0.010	1.968	X		U	
7.42	+/-0.030	7.42	U		T	
10.92	+/-0.030	10.92	2		T	
14.75	+/-0.030	14.75	2		T	

<b>Measured by:</b> B	<b>Audited by:</b> J	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 11-4-20	<b>Date:</b> 11/6/21	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.11.27	New Issue	KJ/EC	AS

R0.38  
(TYP)

0.22

JOGGLE ON THIS  
SIDE WHERE  
SHOWN

D3023-1 BEND DETAIL

D3023-1 FLAT PATTERN

03023-1 BACK PANEL

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES.
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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DART AEROSPACE LTD.

A	01.05.18	NEW ISSUE	
DESIGN	DRAWN BY	<b>DART</b>	DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3023	REV. A SHEET 1 OF 1
DATE 01.05.18		TITLE BACK PANEL	SCALE 1:4